

**\*85456\***

Page 1

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 08/06/2012    **Start Qty:** 100.00

**\*100\***

**Cust Item ID:**

**Required Date:** 22/06/2012      **Req'd Qty:** ~~100.00~~

**\*100\***

**Customer:**

**Reference:**

Approvals: Process Plan: MLJ

Date: 17/06/08

**Tooling:****Date:**

Run Start \*NR1\*

**QC:**

**Date:**

**SPC (Y/N):**

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2651	Rev B								
100		0.00							
<b>*100*</b>	Hardinge CNC LATHE SMALL								
Hardinge	<b>Memo</b>	0.00							
Hardinge CNC Lathe Small 1- Turn as per Folio FA219 and Dwg D26512- Deburr									
110		0.00							
<b>*110*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC	<b>Memo</b>	0.00							
Quality Control									
120		0.00							
<b>*120*</b>	QC8- Inspect parts - second check								
QC	<b>Memo</b>	0.00							
Quality Control									

# Work Order ID 85456

**\*85456\***

Page 2

June-08-12 10:01:42 AM

Item ID: D2651-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Plug

Start Date: 08/06/2012 Start Qty: 100.00

**\*100\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 100.00

**\*100\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

Hand Finishing

203 MB 12-6-25

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*150\***

Powdercoat

Memo

0.00

Powder Coating

(Only larger section necessary) START TIME: 8:50  
OVEN TEMPERATURE: 320°F FINISH TIME: 9:20

203X ✓ M/L 12/07/05

160

QC3- Inspect Part Finish

0.00

**\*160\***

QC

Memo

0.00

Quality Control

203 φ BLD-7-5.

M121841

**Work Order ID 85456****\*85456\***

Page 3

June-08-12 10:01:42 AM

Item ID: D2651-1

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Plug

Start Date: 08/06/2012 Start Qty: 100.00

**\*100\***

Cust Item ID:

Required Date: 22/06/2012 Req'd Qty: 100.00

**\*100\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <i>FP-2</i>	0.00							
<b>*170*</b>									
Packaging	Memo	0.00							
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
<b>*180*</b>									
QC	Memo	0.00							
Quality Control									

*203 0 1275**OK 12/7/10**ME 12-07-05*

# Picklist Print

June-08-12 10:01:46 AM

Page 1

Work Order ID: 85456

**\*85456\***

Parent Item: D2651-1

**\*D2651-1\***

Parent Item Name: Plug

Start Date: 08/06/2012

Required Date: 22/06/2012

Start Qty: 100.00

Required Qty: 100.00

Comments: IPP: A02.04.15New Issue NG  
IPP: B05.12.12added deburr EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6R0.500		Purchased		No		100	f	117.3680	0.0401	4.221053			

**\*M6061T6R0 500\***

6061-T6 Round Bar .500"

**\*\***

*Rp 12.6.21*

Location

Loc Qty

Loc Code

MAT012

117.368

114488

1.997

117379

9.288

119043

106.083

*8.9*



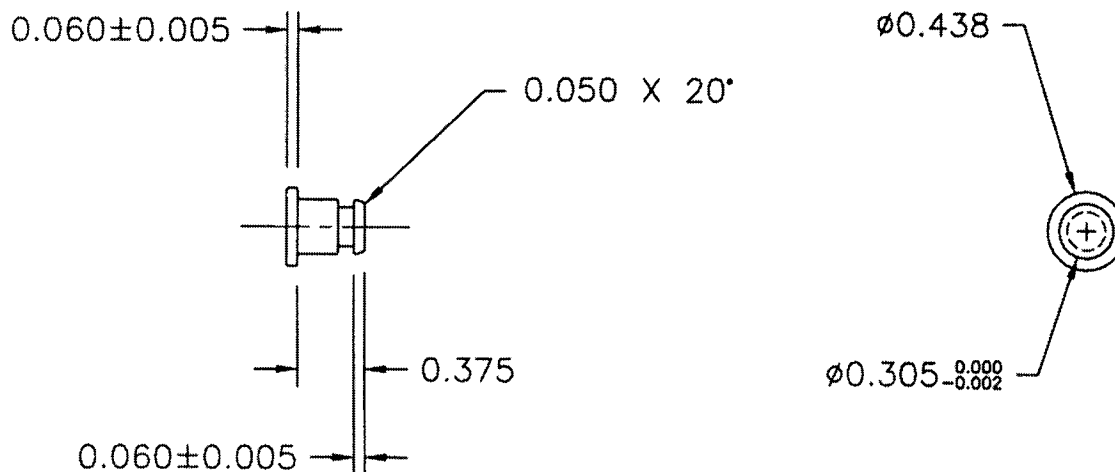


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2651	REV. B SHEET 1 OF 1
DATE 03.12.19		TITLE PLUG	SCALE 1:1
A	97.03.25	NEW ISSUE	
B	03.12.19	ADD POWDER COAT, MS28775-008	

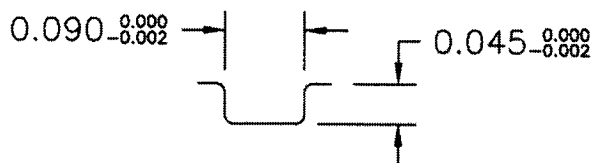
RELEASED

03.12.19 *[Signature]*

### D2651-1 PLUG:



### GROOVE DETAIL (SCALE 5:1)



SHIP COPY  
RETURN TO  
ENGINEERING  
(UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 85456 M 15  
12/06/08)

### D2651-1 PLUG

- 1) MATERIAL: 6061-T6 (QQ-A-225/8) OR 1100-0 (QQ-A-225/1)
- 2) FINISH: ACID ETCH & ALODINE PER DART QSI 005 4.1  
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.010 MAX

### D2651-3 O-RING

- 1) MATERIAL: BUNA N, 70 DUROMETER  
3/16 ID, 5/16 OD, 1/16 WIDTH  
(PARKER 2-008, MS28775-008 OR EQUIVALENT)

Copyright © 1997 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.